

Work Order ID 55752

January 29, 2010 11:08:16 AM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid 205/350

Start Date: 1/29/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

10

Date:

10-1-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: *M113228* 0.00
Large Fab

Memo

0.00

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512
2-Cut (4) D2236 From D3166-3
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
4-Weld as per Dwg D2512 using Welding Jig DT 9436
Deburr as required
INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

SM 10/02/11



110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

QC 10/02/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

8.10/02/10

(X)

Memo

0.00

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

PRESSURE WASH

⇒ 10/02/10

(X) /

Memo M113170

0.00

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 7:30AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 8:00AM

2ND COAT:

START TIME: 8:15AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 8:45AM

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4
Batch: MH3462

= 7 m-l 10/02/16

(IX)

150

0.00



QC

QC3- Inspect Part Finish

Memo

0.00

Quality Control

10/02/16 (X)

160

0.00



Packaging

Identify as per dwg & Stock Location: 6.A

Memo

0.00

Packaging

10/02/16 (X)

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Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/18 JF
MF
10-2-17

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Picklist Print

Page 1

January 29, 2010 11:08:21 AM

Work Order ID: 55752



Parent Item: D2512



Parent Item Name: Basket Lid 205/350

Start Date: 1/29/10

Required Date: 2/08/10

Comments: Rev IPP:M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF
 IPP Rev:N 06.04.05 Added level21 EC
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2012-117 Manufactured No 100 Each 14.0000 2.0000



Clevis

N/A

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	14	
31101	2	
52498	12	

ONLY APPLICABLE ON D130-701-041

D2232-1 Manufactured No 100 Each 4.0000 2.0000



Basket Hinge

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
48230	2	
Main Warehouse		
WA	2	
51105	2	

1355791

2x

LY 10/02/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP Rev:N 06.04.05 Added level21 EC
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2327-1 Manufactured No 100 Each 39.0000 2.0000



Spacer Bushing



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	39	
52832	19	
54658	20	

2x *SY* 10/02/09

D2506 Manufactured No 100 Each 3.0000 1.0000



Label Plate



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
44275	1	
Main Warehouse		
WA	2	
54136	2	

B55700

1x *SY* 10/02/09

January 29, 2010 11:08:21 AM

Shop Packet Print

Page 2

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 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 39.0000 2.0000



Mounting Bracket



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 36

46086 2

48428 1

51120 2

54862 31

Main Warehouse

WA 3

50872 1

51745 2

2x 10/02/09

D3166-3 Manufactured No 100 Each 10.0000 1.0000



Basket Hoop



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 5

48429 5

Main Warehouse

WA 5.000014474

52058 1.4474E-05

54018 5

SAD 10-02-03

January 29, 2010 11:08:21 AM

Shop Packet Print

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP Rev:N 06.04.05 Added level21 EC
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F Purchased No 100 sf 887.4765 18.9474



SAD 10-02-07

Expanded Metal Flat SS

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	887.4765065
111956	0.000017
112147	9.4736E-06
112949	32.58138
113205	0.0093
113497	73.9311
113555	780.9547

18.9474

M304TS0.750W.065 Purchased No 100 f 201.7940 45.8741



SAD 10-02-03

304 SQ Tube .75x.75x.065W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	201.7939742
113082	0.00419
113245	0.00038421
113683	201.7894

45.8741

Main Warehouse

WA	0.0000047
112398	0.0000047

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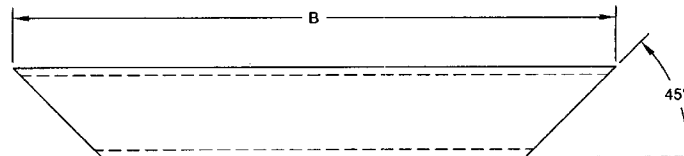
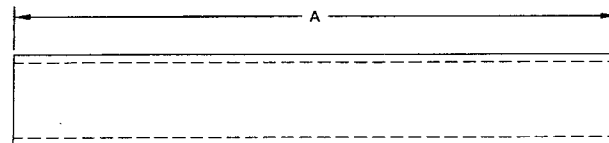
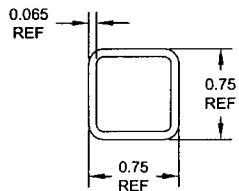
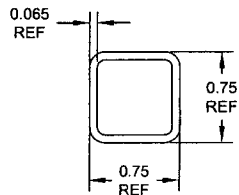
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PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



E

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55752
BY 10-1-29

RELEASED
08.06.21.17

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 8074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

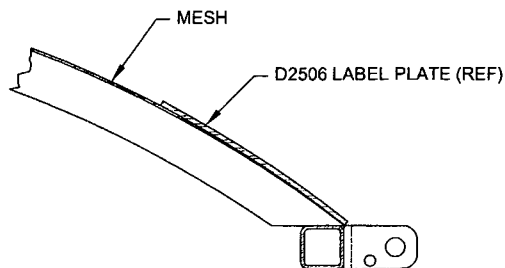
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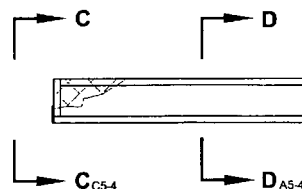
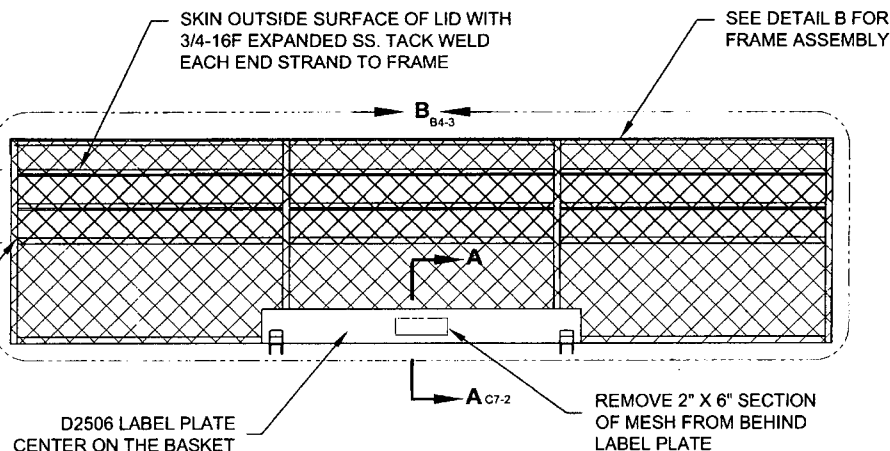
NOTE: Date & initial all entries



SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

RELEASED
05-05-21/11

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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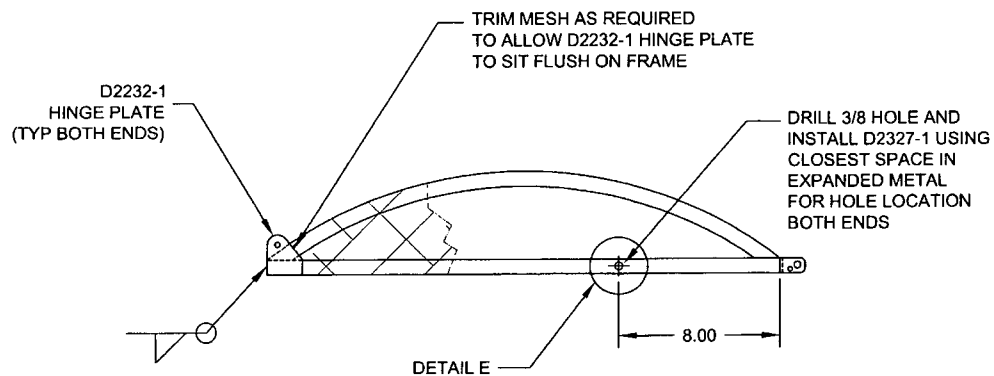
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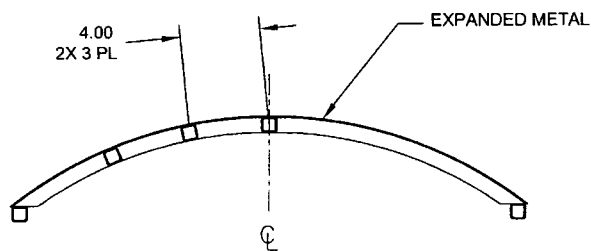
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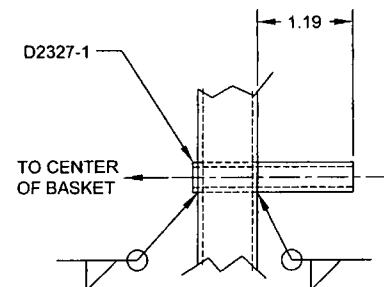
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

RELEASED
05-06-21/14

w/o 55752

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1

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